

Work Order ID 153408

Monday, November 21, 2016 11:23:48 AM

153408

Page 1

Item ID: D139-799-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Engine Wash

Start Date: 11/21/2016 Start Qty: 1.00

1

Required Date: 12/5/2016 Req'd Qty: 1.00

1

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: NOV 22 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN-D139-799

L

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D139-799-015

CHC005

see attachment

DAS
21
9-89DAS
27
9-89

DEC 22 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

fx DAS
27
9-89

DEC 22 2016

DAS
28
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.01

Quality Control

DAS
27
9-89

DEC 22 2016

DEC 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D139-799-015

Location: 3X soldPPP rev: 1X F9194 DAS
27
9-89

DEC 22 2016

140

0.00

140

QC

QC21- Final Inspection - Work Order Release

Memo

0.02

DAS
21
9-89

DEC 22 2016

Quality Control


DEC 22 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Description Work Order Deviation		Disposition		Completed By	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Monday, November 21, 2016 11:23:51 AM

Page 1

Work Order ID: 153408

153408

Parent Item: D139-799-015

D139-799-015

Parent Item Name: Engine Wash

Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 11.07.04 new issue DD verf:JLM IPP REV:B
AS PER ECN 11-598 11-06-05 JLM VERF BY:DD IPP Rev:C 11.09.27
PER CHG003 DD verf:EC IPP Rev:D 13.09.24 PER
CHG005/ECN13-579 DD verf:JLM IPP REV:E 16.10.13 AS PER IIN
REV.L DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C3A

Purchased

No

110

Each

294.0000

4

4

AN3C3A

Bolt

**

Location

Loc Qty

Loc Code

GA

64

m134055

64

ST350

230

m135544

30

m135898

200

AN3C5A

Purchased

No

110

Each

1,214.000

3

3

AN3C5A

Bolt

**

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

96

M135603

96

OVER002

900

M135948

400

M136047

500

ST350

213

M134676

13

M135442

200

DAS
26
9-89

DEC 22 2016

DAS
26
9-89
AS
28
9-89

DEC 22 2016

DAS
27
9-89

DAS
27
9-89

16x.

11x.
1x.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY																																																												
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
																								OTHER : ☐																																							

Picklist Print

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Page 2

Work Order ID: 153408

153408

Parent Item: D139-799-015

D139-799-015

Parent Item Name: Engine Wash

Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

AN526-1032R16

Purchased

No

110

Each

193.0000

4

4

16x.

AN526-1032R16

Screw

**

DAS
2628
9-89

DEC 22 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

ST326

193

m134702

193

110

Each

15.0000

2

2

16x.

AN832-6J

Purchased

No

AN832-6J

Union

**

DAS
2628
9-89

DEC 22 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

OVER007

10

m135864

10

ST324

5

m135603

5

110

Each

29.0000

4

4

m134606 2x.
m135864 1x.

5x.

AN924-6J

Purchased

No

AN924-6J

NUT

**

DAS
2628
9-89

DEC 22 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

4

123245

2

m132256

2

ST322

25

m135864

5

m135948

20

110

Each

18.0000

3

3

5x
11x.

CB2000CRA3-28

Purchased

No

CB2000CRA3-28

Stud

**

DAS
2628
9-89

DEC 22 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

ST590

18

m135951

18

12x

Monday, November 21, 2016 11:23:51 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Monday, November 21, 2016 11:23:51 AM

Page 3

Work Order ID: 153408

153408

Parent Item: D139-799-015

D139-799-015

Parent Item Name: Engine Wash

Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

CB4022V3CR8

Purchased

No

110

Each

18.0000

3

CB4022V3CR8

Anchor Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

ST558

18

m135898

18

CB91

Purchased

No

110

Each

17.0000

2

CB91

Acrylic Adhesive, 3.5g

DAS
27
9-89

Location

Loc Qty

Loc Code

PK

17

m135936

17

D4121-1

Manufactured

No

110

Each

13.0000

2

D4121-1

Hose Assembly

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

3

114101

1

132053

2

ST213

10

151314

2

151979

8

D4121-3

Manufactured

No

110

Each

7.0000

1

D4121-3

Hose Assembly

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

1

91535

1

ST213

6

151315

2

151965

4

Monday, November 21, 2016 11:23:51 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Work Order ID: 153408

153408

Parent Item: D139-799-015

D139-799-015

Parent Item Name: Engine Wash

Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

D4121-5

Manufactured No

110 Each

7.0000

1

D4121-5

Hose Assembly

**

24
144/52X

DEC 2 1 2016

DAS 6 28
9-89 9-89

Location

Loc Qty

Loc Code

ST213

7

151316

3

151945

4

3

D4131-041

Manufactured No

110 Each

0.0000

1

D4131-041

Manifold Assembly

**

24
153 (45 586) 15432X

DEC 2 1 2016

DAS 6 28
9-89 9-89

D4131-043

Manufactured No

110 Each

9.0000

1

D4131-043

Doubler Assembly

**

24
142 89/1X1

DEC 2 1 2016

DAS 6 28
9-89 9-89

Location

Loc Qty

Loc Code

ST085

9

151726

4

151915

5

3
28

D4146-1

Manufactured No

110 Each

13.0000

2

D4146-1

Fitting

**

DEC 2 1 2016

DAS 6 28
9-89 9-89

Location

Loc Qty

Loc Code

ST085

13

149637

4

151897

9

4
4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Picklist Print

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Work Order ID: 153408

153408

Parent Item: D139-799-015

D139-799-015

Parent Item Name: Engine Wash

Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

D4182-1

Manufactured No

110

Each

14.0000

2

D4182-1

Fitting, Quick Disconnect

**

28
153585X2 DEC 2 1 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

ST089

14

144155

2

151318

6

151943

6

DAS
28
9-89

D4384-1

Manufactured No

110

Each

11.0000

1

D4384-1

Placard

**

14
DEC 2 1 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

5

80679

5

ST095

6

151317

6

143816x1

3

DAS
28
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Page 6

Work Order ID: 153408

153408

Parent Item: D139-799-015

D139-799-015

Parent Item Name: Engine Wash

Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

110

Each

828.0000

MS21043-3

Nut

Location

Loc Qty

Loc Code

CCK007

400

m135864

400

FG

80

103691

80

FP001

11

m130673

11

GA

45

m133990

45

ST302

223

m135704

223

ST304

69

m131340

69

MS21043L3

MS21043L3

Nut

Purchased

No

110

Each

0.0000

6

**

MS21919WCH16

Purchased

No

110

Each

12.0000

2

**

MS21919WCH16

Clamp

Location

Loc Qty

Loc Code

ST291

12

m135910

12

MS21919WCH4

Purchased

No

110

Each

12.0000

2

**

MS21919WCH4

Clamp

Location

Loc Qty

Loc Code

ST291

12

m135910

12

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Work Order ID: 153408

153408

Parent Item: D139-799-015

D139-799-015

Parent Item Name: Engine Wash

Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

MS21919WCH9 Purchased No 110 Each 24.0000 4

MS21919WCH9

Clamp

DAS
27
9-89

Location

Loc Qty

Loc Code

ST290

24

m135898

24

MS21919-WDG9 Purchased No 110 Each 92.0000 9

MS21919-WDG9

Clamp

DAS
27
9-89

Location

Loc Qty

Loc Code

ST293

92

m135865

92

NAS1149C0316R AN960C10LL Purchased No 110 Each 0.0000 6

NAS1149C0316R

WASHER

DAS
27
9-89

NAS1149C0332R Purchased No 110 Each 3,484.000 8

NAS1149C0332R

WASHER

Location

Loc Qty

Loc Code

FP001

842

m135672

530

m135948

312

GA

86

m133284

86

ST260a

1500

m135466

1000

m136042

500

ST266

1056

m135408

356

m135766

500

m135908

200

DAS
27
9-89

DAS 28 9-89
DEC 21 2016

DAS 28 9-89
DEC 21 2016

DAS 28 9-89
DEC 21 2016

DAS 28 9-89
DEC 21 2016

~~m135948~~

~~3254~~ 32

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____ _____ _____			
Misidentified ☐		Past Due ☐					

Picklist Print

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Page 8

Work Order ID: 153408

153408

Parent Item: D139-799-015

D139-799-015

Parent Item Name: Engine Wash

Start Date: 11/21/2016

Required Date: 12/5/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0932R

Purchased

No

110

Each

128.0000

4

NAS1149C0932R

WASHER

DAS
27
9-89

Location

Loc Qty

Loc Code

ST265

128

m134702

128

NAS43DD3-80N

NAS43DD3-
68FC

Purchased

No

110

Each

18.0000

3

NAS43DD3-80N

Spacer

DAS
27
9-89

Location

Loc Qty

Loc Code

ST550

18

m135898

18

**

DEC 21 2016

DAS
28
6 9-89
9-89

**

DEC 21 2016

DAS
28
6 9-89
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____	

Linda Lacelle

From: Marc Bellavance
Sent: Wednesday, October 19, 2016 8:23 AM
To: Linda Lacelle; Harvey Siemens
Subject: RE: D139-799-015

Good Morning Linda,

As far as I know, there is no such thing as an "L3" P/N. My understanding is that the "L" stands for "Lubricant". At least, that's what the MS21043 Spec tells me. However the MS21043 Spec refers back to MIL-N-25027 which has more to do with design/fabrication of self-locking nut, 250° and 450°F and offer no "L" variant to the P/Ns. Based on this, our IIN should call for qty(10) MS21043-3 nuts.

Marc

From: Linda Lacelle
Sent: October-19-16 7:38 AM
To: Harvey Siemens <hsiemens@dartaero.com>; Marc Bellavance <mbellavance@dartaero.com>
Subject: D139-799-015
Importance: High

Good Morning,

The IIN for the D139-799-015 has both MS21043-3 and MS21043L3, is this a typo? Aren't these the same, like the MS21042-3/MS21042L3 per our QSI017 ? we are trying to get these kits picked to ship to the customer....

Thx

Linda

Qty -015	Part Number	Description
X	D139-799-015	ENGINE WASH KIT
2	D4121-1	HOSE ASSEMBLY
1	D4121-3	HOSE ASSEMBLY
1	D4121-5	HOSE ASSEMBLY
1	D4131-041	MANIFOLD ASSEMBLY
1	D4131-043	DOUBLER ASSEMBLY
2	D4146-1	FITTING
2	D4182-1	FITTING, QUICK DISCONNECT
1	D4384-1	PLACARD
3	AN3C5A	BOLT (or NAS6603-4)
4	AN3C3A	BOLT
4	AN526-1032R16	SCREW
2	AN832-6J	UNION (or AN837-6J)
4	AN924-6J	NUT
4	MS21043-3	NUT
6	MS21043L3	NUT
4	NAS1149C0932R	WASHER (or AN960C916L)
8	NAS1149C0332R	WASHER (or AN960C10L)
6	NAS1149C0316R	WASHER (or AN960C10LL)
3	NAS43DD3-80N	SPACER
9	MS21919WDG09	CLAMP (or AS21919WDG09)
2	MS21919WCH4	CLAMP (or AS21919W CH4)
4	MS21919WCH9	CLAMP (or AS21919W CH9)
2	MS21919WCH16	CLAMP (or AS21919W CH16)
3	CB2000CRA3-28	STUD (or A366A3E30C)
3	CB4022V3CR8	ANCHOR NUT (or AW001TL3A08)
2	CB91	3.5g ACRYLIC ADHESIVE KIT

Work Order ID 153408

Wednesday, December 21, 2016 2:38:36 PM

153408

Page 1

Item ID: D139-799-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Engine Wash

Start Date: 11/21/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/5/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D139-799

L

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D139-799-015
CHG005*chg 006 see attachment*DAS
21
9-89

DEC 21 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
21
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.02

Quality Control

Change Record

PAGE 1 OF 1

Part Number: D139-799-015Description: ENGINE WASH[illegible]